



ORIGINAL

4090

13. AFT ADJUSTABLE BLADE SUPPORT ASSY

④ -11 FWD ADJUSTABLE BLADE SUPPORT ASSY

06210 3140



Date: Thursday, 24/07/2008 8:21:26 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40607

Part Number: PB674300113

Job Number:



Seq. #: Machine Or Operation:

Description :

20.0 QC5

INSPECT WORK TO CURRENT STEP



S 08/09/15 82

Comment: INSPECT WORK TO CURRENT STEP

21.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 509

8/9/15

(xa) 509

22.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-12

Job Completion





Date: Thursday, 24/07/2008 8:21:26 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number: 40607		Part Number: PB674300113
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION
15.0	PB674300169	90 Degree Cover Plate  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) 90 Degree Cover Plate batch: 840069
16.0	PB674300183	PB67-43001-83  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-83 batch: 40096
17.0	MS27039110	Screw  Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) Screw batch: M102984
18.0	NAS1149F0316P	WASHER  Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s) WASHER batch: M108473
19.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number: 40607		Part Number: PB674300113
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		
Comment: LARGE FABRICATION RESOURCE 1 1- make a 0.090" chamfer in the 1.00" hole before welding 2- assemble parts and weld as per dwg		<i>12 08-07-29 5</i>
7.0	QC9	VISUAL WELDING INSPECTION
		
Comment: VISUAL WELDING INSPECTION		<i>12 08-01-29 R</i>
8.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		<i>12 08-01-29 R</i>
9.0	MS124780	HELICAL INSERT
		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) HELICAL INSERT		<i>12 08-01-29 R</i>
10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- grind weld flush in area of PB67-43001-249 only 2- tap drill for helical 3- install helical insert as per dwg		<i>12 08-07-31</i>
11.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		<i>12 08-07-31 R</i>
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>12 08-07-31</i>
13.0	POWDER COATING	POWDER COATING
		
Comment: POWDER COATING 1- MASK TUBE FROM BASE TO GUSSET 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3		<i>12 08-07-31</i>



SPUR

Dart Aerospace Ltd.

Date: Thursday, 24/07/2008 8:21:26 AM  
 User: Melanie Fauteux

## Process Sheet

Duplicate

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 40607  
 Estimate Number : 13436  
 P.O. Number :  
 This Issue : 24/07/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 17/07/2008 Type : LARGE FAB ASSY  
 Previous Run :  
 Written By :  
 Checked & Approved By : MF 08-07-24  
 Comment : Est Rev:A 08-06-26 new issue DD verified by:ec

Drawing Name : AFT ADJUSTABLE BLADE SUPPORT ASSY  
 Part Number : PB674300113  
 Drawing Number : B6743001 P.8  
 Project Number : N/A  
 Drawing Revision : B1  
 Material :  
 Due Date : 24/07/2008  
 Qty: 2 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001255	Inner Tube  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: 40591
2.0	PB6743001249	Inner Tube Bushing  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: m18147
3.0	PB6743001253	Gusset  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340717
4.0	PB6743001254	Gusset  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: 340053
5.0	PB674300167	PB67-43001-67  Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB67-43001-67 batch: 340243